

Date: Monday, 10/22/2007 3:38:42 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JOGGLE BRACKET
Job Number : 35320	
Estimate Number : 12912	
P.O. Number : N/A	Part Number : D35801
This Issue : 10/22/2007 S.O. No. : N/A	Drawing Number : D3580 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 10/22/2007 Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 35291	Material : N/A
Written By : <u>JS 07-10-22</u>	Due Date : 10/29/2007 Qty: 50 Um: Each
Checked & Approved By : <u>JS 07-10-22</u>	
Comment : Est Rev : A New Issue 07.06.25 EC	
Est Rev : B Removed Powder Coat 07-07-11 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S18GA 304/316 .050 Sheet



.483



Comment: Qty.: 0.0105 sf(s)/Unit Total : 0.5250 sf(s)

304/316 SS sheet 0.050" thick

Batch: 100997 HB 07-10-23

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3580

Dwg Rev: BProg Rev: B

HB 07-10-23

(46)

2-Deburr if necessary

SAD 07-10-23

46 coated

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 07-10-23



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JS 07/10/24 (46)

counter

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Bend as per dwg D3580 using 1/8" offset die

JS 07/10/24

(46)

Date: Monday, 10/22/2007 3:38:42 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JOGGLE BRACKET

Job Number: 35320

Part Number: D35801

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

S 07/10/25

(46)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/10/25 (46)

8.0

QC21

FINAL INSPECTION W/O RELEASE



(46)

Comment: FINAL INSPECTION W/O RELEASE

RD 07/10/26

Job Completion



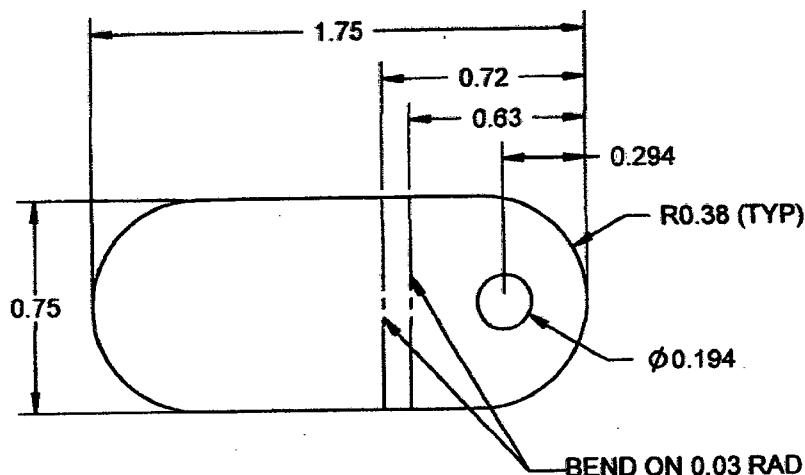
U 07-10-25



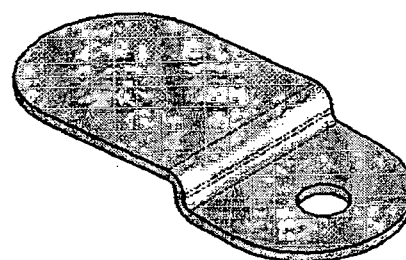
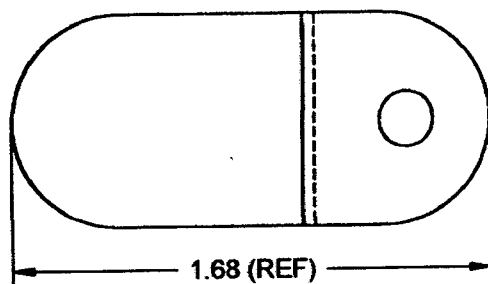
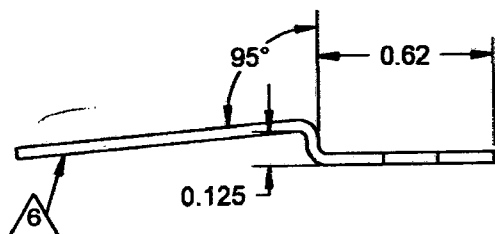
DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	SCALE 3:2
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED

07.07.09 *[Signature]*



D3580-1F FLAT PATTERN



D3580-1 JOGGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

